

# Work Order ID 152133

Thursday, October 27, 2016 3:47:56 PM

**\*152133\***

Page 1

Item ID: D350-588-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Aft Door Assembly

Start Date: 10/25/2016 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 10/26/2016 Req'd Qty: 1.00

**\*1\***

Customer: CAIRM02

Reference: RMA RA112375

Approvals: Process Plan: ME

Date: 10-10-27

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D2445/D350-588

Rev D/D

DSI9690

A

**SCRAP**

100

**\*100\***

QC

Quality Control

## Memo

INSPECT RA112375  
D350-588-041 X 1 B140735

DOOR NEEDS TO BE SENT OUT FOR REPAIR

## REMOVE AND ID :

- D2143 X 1 B121806 ✓
- D2144 X 1 B114332 ✓
- D2585 X 2 B139075 ✓
- D2586 X 2 B139228 ✓
- D2621 X 2 B127749 ✓
- D2857-1 X 1 B133964 ✓
- D2857-2 X 1 B133903 ✓

SCRAP D2463-0870 AND ALL HARDWARE

DAS  
07  
9-89

17/01/17

DAS  
07  
9-89

17/01/17

**105\***  
**SMALL FAB**

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Item ID: D350-588-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Aft Door Assembly  
 Start Date: 10/25/2016 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 10/26/2016 Req'd Qty: 1.00 **\*1\*** Customer: CAIRM02  
 Reference: RMA RA112375

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                                                                                                                                                                                                   | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 110                            |                                                                                                                                                                                                                            | 0.00                 |         |        |              |               |               |                  |                |
| <b>*110*</b>                   |                                                                                                                                                                                                                            |                      |         |        |              |               |               |                  |                |
| Purchasing                     | Memo                                                                                                                                                                                                                       | 0.00                 |         |        |              |               |               |                  |                |
| Purchasing                     | SEND OUT TO FDC FOR REWORK:<br>Issue P/O: <u>35626</u><br>Description: D2445 Baggage Door<br>Supplier: FDC composite<br>Ship to supplier (1) D0588-041 label<br>Certification of Conformity and process sheet is required. |                      |         |        |              |               |               |                  |                |
| 120                            | Receive & Inspect for Damage & Mat'l Certs                                                                                                                                                                                 | 0.00                 |         |        |              |               |               |                  |                |
| <b>*120*</b>                   |                                                                                                                                                                                                                            |                      |         |        |              |               |               |                  |                |
| Packaging                      | Memo                                                                                                                                                                                                                       | 0.00                 |         |        |              |               |               |                  |                |
| Packaging                      | Ensure Certificate of Conformity & Process Sheet are attached                                                                                                                                                              |                      |         |        |              |               |               |                  |                |
| 130                            | QC6- Inspect dimensions to drawing                                                                                                                                                                                         | 0.00                 |         |        |              |               |               |                  |                |
| <b>*130*</b>                   |                                                                                                                                                                                                                            |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                                                                                                                                                                                                       | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                | Inspect as per Dwg D2445.<br>Audit process sheet.                                                                                                                                                                          |                      |         |        |              |               |               |                  |                |

*N/A*  
*JUL 27 2017*

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Item ID: D350-588-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Aft Door Assembly  
Start Date: 10/25/2016 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 10/26/2016 Req'd Qty: 1.00 **\*1\*** Customer: CAIRM02  
Reference: RMA RA112375

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID                | Operation<br>Description                                                                                                                                                         | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|-----------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 140<br><b>*140*</b><br>Small Fab<br>Small Fab | <b>Memo</b><br>Assemble all of the above parts as per Dwg D350-588<br><br>*AFTER REWORK IS COMPLETE FROM FDC, TRIAL FIT DOOR AND<br>ASSEMBLE WITH ORIGINAL KIT AND NEW HARDWARE* | 0.00<br>0.00         |         |        |              |               |               |                  |                |
| 150<br><b>*150*</b><br>QC<br>Quality Control  | QC5- Inspect part completeness to step on W/O<br><br><b>Memo</b>                                                                                                                 | 0.00<br>0.00         |         |        |              |               |               |                  |                |
| 160<br><b>*160*</b><br>Packaging<br>Packaging | Pick Kit<br><br><b>Memo</b><br>ENSURE ORIGINAL KIT IS WITH DOOR                                                                                                                  | 0.00<br>0.00         |         |        |              |               |               |                  |                |

*N/A*  
*JUL 27 2017*

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Item ID: D350-588-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Aft Door Assembly

Stop **\*NS2\***

Start Date: 10/25/2016 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 10/26/2016 Req'd Qty: 1.00

**\*1\***

Customer: CAIRM02

Reference: RMA RA112375

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

170

QC4- 100% Inspect kits for completeness

0.00

**\*170\***

QC

Memo

0.00

Quality Control

180

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*180\***

Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

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# Picklist Print

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Work Order ID: 152133

**\*152133\***

Parent Item: D350-588-041

**\*D350-588-041\***

Parent Item Name: Aft Door Assembly

Start Date: 10/25/2016

Required Date: 10/26/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP P 04.02.04ReformatKJ/DS IPP Rev:Q as  
per DSI9414 DD verified by:EC IPP Rev:R add pick kit DD  
10.03.29 verified by:EC IPP REV:S 14.04.28 AS PER  
DSI9690 DD VERF:JLM

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty         | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|----------------------|---------------|----------------|--------|
| D350-588-041                    |                        | Manufactured  | No          |                     |                  |                 | Each               | 0.0000         |             | 1                    |               |                |        |
| <b>*D350-588-041*</b>           |                        |               |             |                     |                  |                 |                    |                |             | <b>**</b>            |               |                |        |
| Aft Door Assembly               |                        |               |             |                     |                  |                 |                    |                |             | <u>1 x 140735 MF</u> |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |             | 16-10-27             |               |                |        |

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Work Order ID: 152133

**\*152133\***

Parent Item: D350-588-041

**\*D350-588-041\***

Parent Item Name: Aft Door Assembly

Start Date: 10/25/2016

Required Date: 10/26/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP P 04.02.04ReformatKJ/DS IPP Rev:Q as  
per DSI9414 DD verified by:EC IPP RevR add pick kit DD  
10.03.29 verified by:EC IPP REV:S 14.04.28 AS PER DSI9690 DD  
VERF:JLM IPP RevT 17.06.01 DSI9760-011 DP Verify DD

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D2143 Manufactured No

Each 32.0000

**\*D2143\***

Hinge Bracket

\*\*

JUL 27 2017

Location

Loc Qty

Loc Code

ST002

32

121806

1

141033

1

150285

8

152427

10

156245

12

D2144 Manufactured No

Each 33.0000

**\*D2144\***

Hinge Doubler

\*\*

JUL 27 2017

Location

Loc Qty

Loc Code

ST002

19

114332

1

150971

18

ST012a

14

156274

14

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Work Order ID: 152133

**\*152133\***

Parent Item: D350-588-041

**\*D350-588-041\***

Parent Item Name: Aft Door Assembly

Start Date: 10/25/2016

Required Date: 10/26/2016

Start Qty: 1.00

Required Qty: 1.00

D2585

Manufactured No

Each 51.0000

**\*D2585\***

Latch Clamp

\*\*

139075  
Loc Code

-2  
M

JUL 27 2017

Location

Loc Qty

ST008

51

139075

2

152476

9

156309

4

161798

18

162498

18

D2586

Manufactured No

Each 49.0000

**\*D2586\***

Door Latch

\*\*

139228  
Loc Code

-2  
M

JUL 27 2017

Location

Loc Qty

FG

12

139228

6

152211

4

154875

2

ST448a

27

139228

2

161467

25

ST481

10

154875

10

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Work Order ID: 152133

**\*152133\***

Parent Item: D350-588-041

**\*D350-588-041\***

Parent Item Name: Aft Door Assembly

Start Date: 10/25/2016

Required Date: 10/26/2016

Start Qty: 1.00

Required Qty: 1.00

D2621

Manufactured No

Each 30.0000

**\*D2621\***

Latch Plate

Location

Loc Qty

Loc Code

FG  
88616  
ST009  
127749  
141106  
142793  
150495

2  
2  
28  
2  
1  
10  
15

\*\*

-2  
N

JUL 27 2017

D2857-1

Manufactured No

Each 20.0000

**\*D2857-1\***

Hinge Bracket

Location

Loc Qty

Loc Code

FG  
144748  
150331  
91914  
ST012  
133964  
152448

5  
1  
3  
1  
15  
1  
14

\*\*

-1  
N

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Work Order ID: 152133

**\*152133\***

Parent Item: D350-588-041

**\*D350-588-041\***

Parent Item Name: Aft Door Assembly

Start Date: 10/25/2016

Required Date: 10/26/2016

Start Qty: 1.00

Required Qty: 1.00

D2857-2

Manufactured No

Each 30.0000

**\*D2857-2\***

Hinge Bracket

\*\*

JUL 27 2017

Location

Loc Qty

|        |    |
|--------|----|
| FG     | 9  |
| 140972 | 2  |
| 152184 | 7  |
| ST012  | 9  |
| 133903 | 1  |
| 152184 | 8  |
| ST012a | 12 |
| 161675 | 12 |

Loc Code

133903